

Work Order ID 101450

101450

Page 1

May-13-13 10:29:56 AM

Item ID: D2230-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 5/13/13

Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 300.00

300

Customer:

Reference:

Approvals:

Process Plan:

Date: 13/05/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"

Batch:

CL 13/05/13

(300)

cut to meter.

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927

FOLIO REV:

DWG REV:

Check for crack while loading into the machine.

2- deburr

P/O 19868

CL 13/05/13 300

issue P/O to meter:

machine D2230REV.G

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Item ID: D2230-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 5/13/13 Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/17/13 Req'd Qty: 300.00

300

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *see'd*

QC2 Inspect parts off machine FAL/FAIB

0.00

120

QC

Memo

0.00

Quality Control

*see'd + inspect
attached c/c to w/o*

130

QC3 Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

13-6-14

*100
cont*

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

100 16-6-17

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Item ID: D2230-3

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 5/13/13

Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 300.00

300

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

100X φ m/f 13/06/17

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:20

OVEN TEMPERATURE: 320 °F

FINISH TIME: 11:50

100X φ m/f 13/06/17

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

100 φ B6-17.



m125620

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Item ID: D2230-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Lug

Start Date: 5/13/13

Start Qty: 300.00

300

Cust Item ID:

Required Date: 5/17/13

Req'd Qty: 300.00

300

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: ST-469

0.00

190

Packaging

Memo

0.00

Packaging

69x 11.11.13-06-20
SP

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

11.13-06-21

11.13-06-21

Picklist Print

May-13-13 10:29:55 AM

Page 1

Work Order ID: 101450

Parent Item: D2230-3

Parent Item Name: Lug

Start Date: 5/13/13

Required Date: 5/17/13

Start Qty: 300.00

Required Qty: 300.00

Comments: IPP D00.05.18Added inspection level 8, and removed P/O for powder
coatEC
BY:EC
IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P LUG		Purchased	No				Each	0.0000		300		5/13/13 (100)	
D2423 Lug Extrusion		Manufactured	No			100	f	588.7400	0.0683	21.568421		5/13/13	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT006		383							
				43722		161.5							
				87953		221.5							
				Metec		205.74							
				93551		205.74							
										21.57			

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL

0.273
REF

0.306

0.345

SYM ABOUT

1.200

R0.125
REF

0.250

0.735
REF

MACHINE TO
SIZE

D2230-1

6

MACHINE TO
SIZE

1.91

0.400

0.025
REF

R0.38
REF

0.375

3.700

$\phi 0.257^{+0.005}_{-0.000}$

0.750

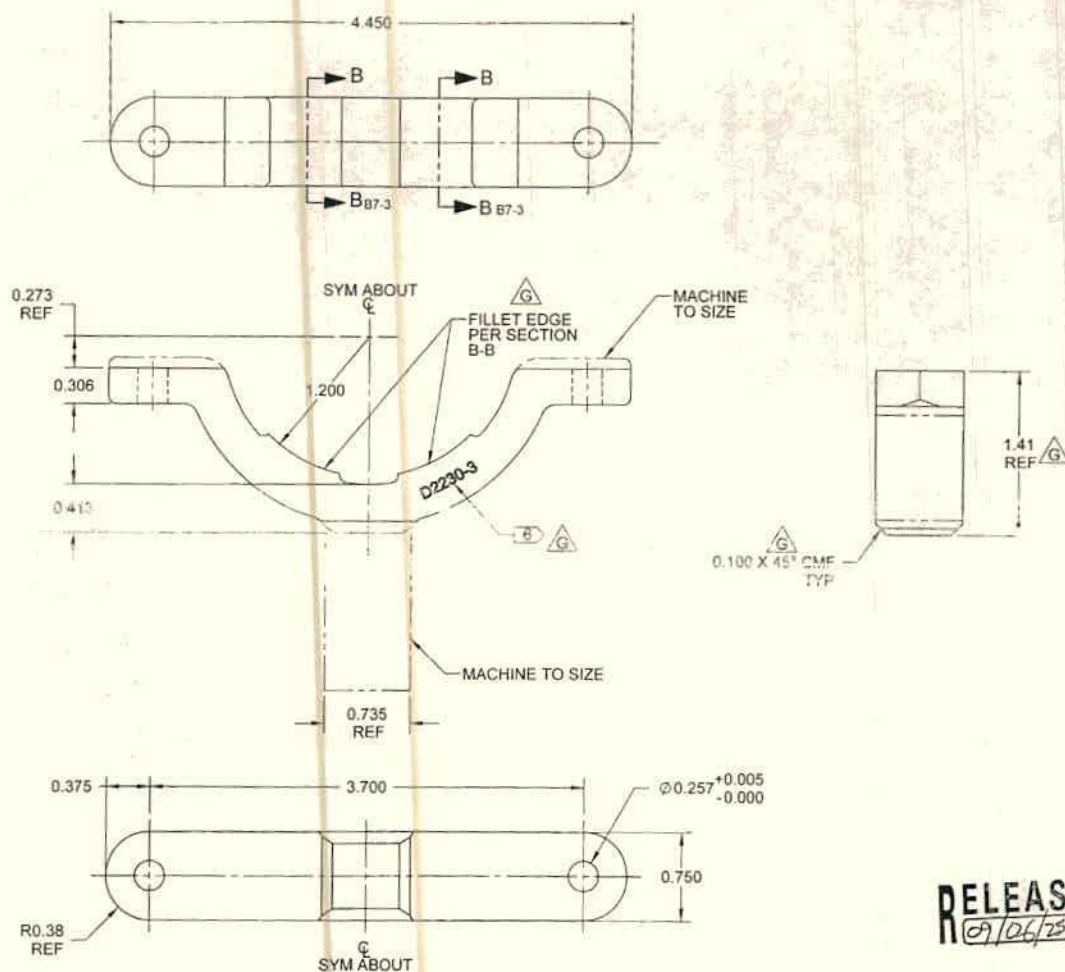
R0.38
REF

SYM ABOUT

D2230-1 MOUNTING LUG

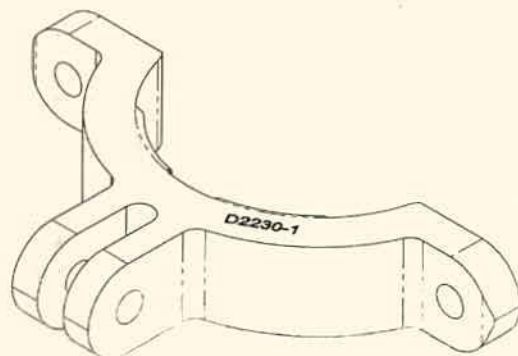
RELEASED
09/06/75

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE MOUNTING LUG	SHEET 2 OF 3
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CONVEYED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.16		



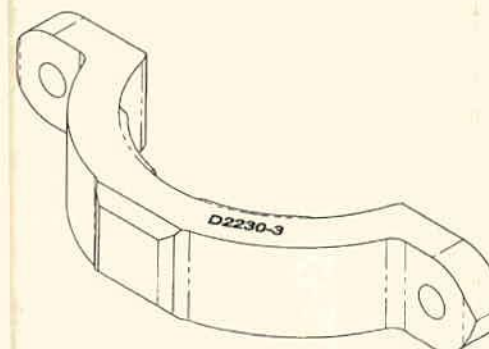
RELEASE
09/06/25/14

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	N78
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D2230-1 MOUNTING LUG

CL 13/05/13
W10.101450



D2230-3 MOUNTING LUG

RELEASED
09/01/16



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19056
Date: Jun 05, 2013
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 19868	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date: Jun 06, 2013

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug as per drawing D2230 REV.G , B101450	Each	300	100	
D2230-3 Mounting Lug as per drawing D2230 REV.G, B101495	Each	300	175	
D2230-1 Mounting Lug as per drawing D2230-1 REV.G, B101834	Each	320		120
D3235-1 Mounting Lug as per drawing D3235-1 REV.A, B101559	Each	200		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by

Sonia Plouffe

Thank you for your order!



METAL TECHNOLOGY INC.

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

275

D2230-3

Lug

PO 19868

100+175

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, June 6, 2013